

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026440**Date Inspected:** 29-Sep-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Bonifacio Daquinag Jr.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Sections**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above.

This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and monitor American Bridge/Fluor (ABF) welding operations. This Quality Assurance (QA) Inspector, Craig Hager observed the following.

Self Anchored Suspension (SAS) Tower section, Electro Slag Welding (ESW) joints:

ESW weld joint, locations "N" and "W": This QA Inspector was informed by QC Inspector Steve McConnell that QC personnel had completed the visual and Magnetic Particle Testing (MT) from both faces and the preliminary Ultrasonic Testing (UT) from face – A at both of these locations. This QA Inspector informed Lead QA Inspector Danny Reyes of the conversation and was requested to perform a preliminary UT verification on a minimum of 10% of the overall weld length from face – A. This QA Inspector performed a random UT verification inspection (preliminary) from Y-800 to Y-1800 (1,000 mm which is slightly greater than 10% of the overall weld length) at both ESW weld joint locations. This QA Inspector used a 70 degree shearwave transducer wedge combination, scanning from the outside (face – A). This QA Inspector performed the inspection using both the first and second leg of the sound path. This QA Inspector observed the QC procedure only requires the examination to be performed using the first leg. This QA Inspector also used a longitudinal wave (90 degree) transducer from the same scanning face for laminations in the base material within range of the shearwave inspection. At this time this QA Inspector did not observe any UT signals indicating a defect, recordable indication or sizable lamination. This QA Inspector informed Lead QA Inspector Danny Reyes of the findings

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Summary of Conversations:

This QA Inspector had general conversations with American Bridge/Fluor (ABF) and Caltrans personnel during this shift. Except as described above and noted above there were no notable conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Hager,Craig	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
